

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

| ITEM | QTY -041 | QTY -043 | QTY -045 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|---------------|-------------------------------------------|
| 1 | X | | | D3887-041 | STD SKIDTUBE ASSY WITH WEARPAD |
| 2 | | X | | D3887-043 | STD SKIDTUBE ASSY WITH WEARPLATE |
| 3 | | | X | D3887-045 | STD SKIDTUBE ASSY WITH TRAINING WEARPLATE |
| 10 | 2 | 2 | 2 | D2579 | CROSS BOLT SPACER |
| 11 | 2 | 2 | 2 | D2855-3 | CAP |
| 12 | 16 | 16 | | D3492-045 | PLUG ASSY |
| 13 | 2 | 2 | 2 | D3672-1 | PHENOLIC WASHER |
| 14 | 8 | 8 | 8 | D3681-1 | SPACER |
| 17 | 5 | 5 | | D3847-1 | WEARPAD |
| 18 | 1 | 1 | | D3847-11 | AFT WEARPAD |
| 19 | | 1 | | D3847-043 | FWD WEARPLATE ASSY |
| 20 | | 1 | | D3847-045 | CENTER WEAPLATE ASSY |
| 21 | | 1 | | D3847-047 | AFT WEARPLATE ASSY |
| 22 | | | 1 | D3849-041 | FWD TRAINING WEARPLATE ASSY |
| 23 | | | 1 | D3849-043 | AFT WEARPLATE ASSY |
| 24 | 1 | 1 | 1 | D3885-1 | STANDARD WEB |
| 25 | 1 | 1 | | D3887-11 | STANDARD SKIDTUBE |
| 26 | | | 1 | D3887-13 | STANDARD SKIDTUBE |
| 27 | 12 | 12 | 12 | D3903-1 | SPACER |
| 28 | | | 16 | D3904-1 | WASHER |
| 41 | 30 | 30 | | ALS4-1032-130 | INSERT |
| 42 | 32 | 32 | 2 | AN3C5A | BOLT |
| 43 | | | 8 | AN3C46A | BOLT |
| 44 | 32 | 32 | | NAS1149C0332R | WASHER (OR AN960C10L) |
| 45 | | | 8 | MS21043-3 | NUT |
| 46 | 2 | 2 | 2 | MS24694-C52 | SCREW |

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UNDER REVIEW

2014 NOV 24
ECN 14-628

15.04.30 URF15-560 AP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs
D3887-043 = 37.0 lbs
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO $\phi 0.197$ HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

| | | | |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| D | REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 135.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-8), ADD 116.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2) | DB | 13.09.20 |
| C | (SHT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS, (ZN C1-5, C1-6, B4-7) $\phi 0.201$ CSK $\phi 0.385 \times 100$ WAS $\phi 0.214$ THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7) | DB | 13.02.19 |
| B | ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); $\phi 0.313$ WAS $\phi 0.328$ (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE IV (ZN B3-7) | RF | 09.06.30 |
| A | NEW ISSUE | RF | 09.03.30 |
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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

1.5
1.5

2.00 DISTANCE TO D3885-1 WEB, REF

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

1.5

D2855-3 CAP

1.5

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3847-11
WEARPAD

AN3C5A BOLT
NAS1149C0332R WASHER
24 PL

PLUG UNUSED INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

D3847-1
WEARPAD
5 PL

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3887-11)

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15.04.30 URF15-560 AP

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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3847-11
WEARPAD

D3847-047
AFT WEARPLATE ASSY

AN3C5A BOLT
NAS1149C0332R WASHER
30 PL

D3847-045
CENTER WEARPLATE ASSY

D3847-043
FWD WEARPLATE ASSY

D3847-1
WEARPAD
5 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø 0.197
8 PL PER SIDE
REF

1.5
1.5
1.5

2.00 DISTANCE TO D3885-1 WEB, REF

1.5
1.5

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3887-11)

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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
8 PL

D3849-043
AFT TRAINING WEARPLATE ASSY

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

2.00 DISTANCE TO D3885-1 WEB

D3849-041
FWD TRAINING WEARPLATE ASSY

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

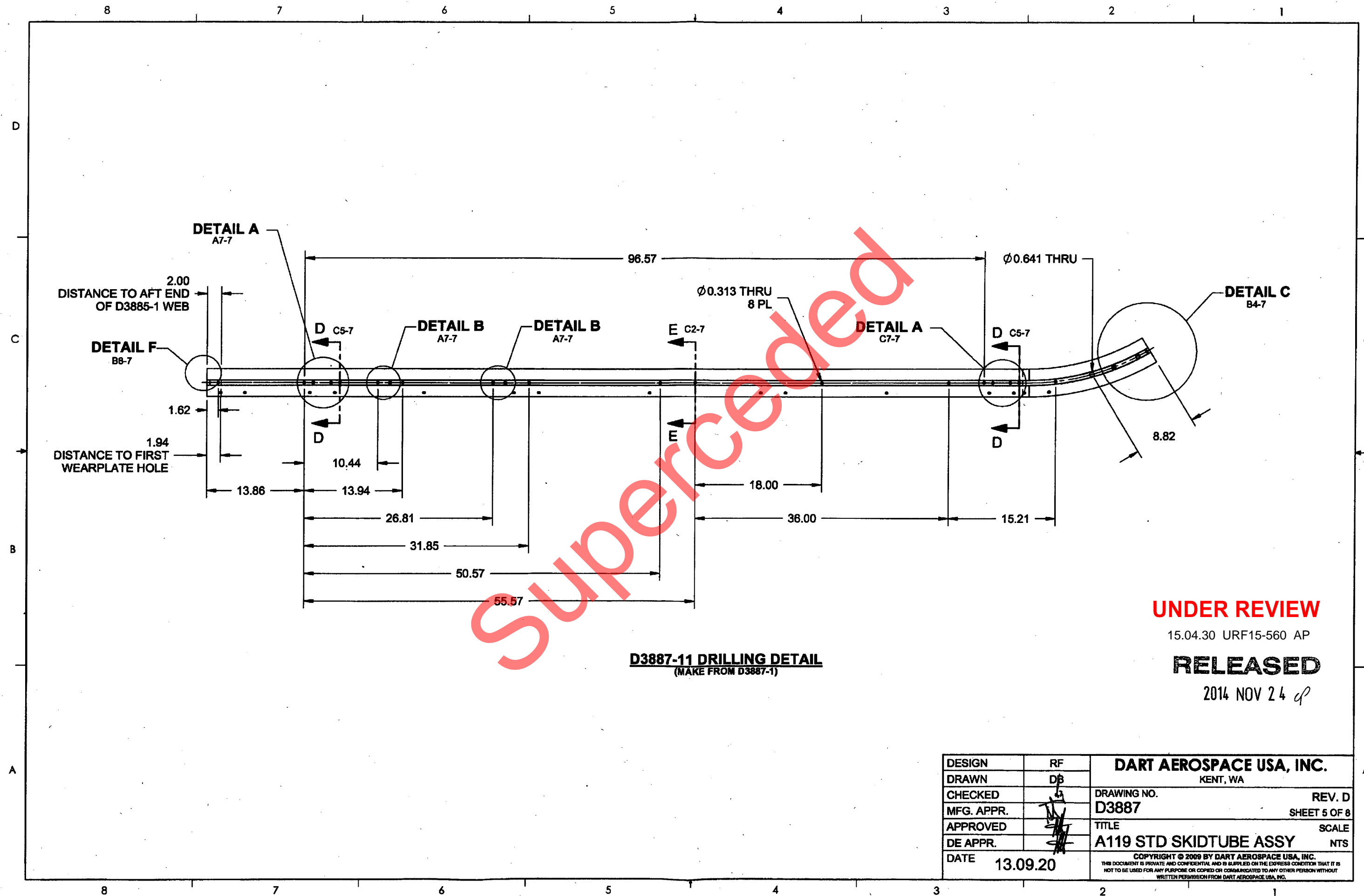
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D3887-11 DRILLING DETAIL
(MAKE FROM D3887-1)

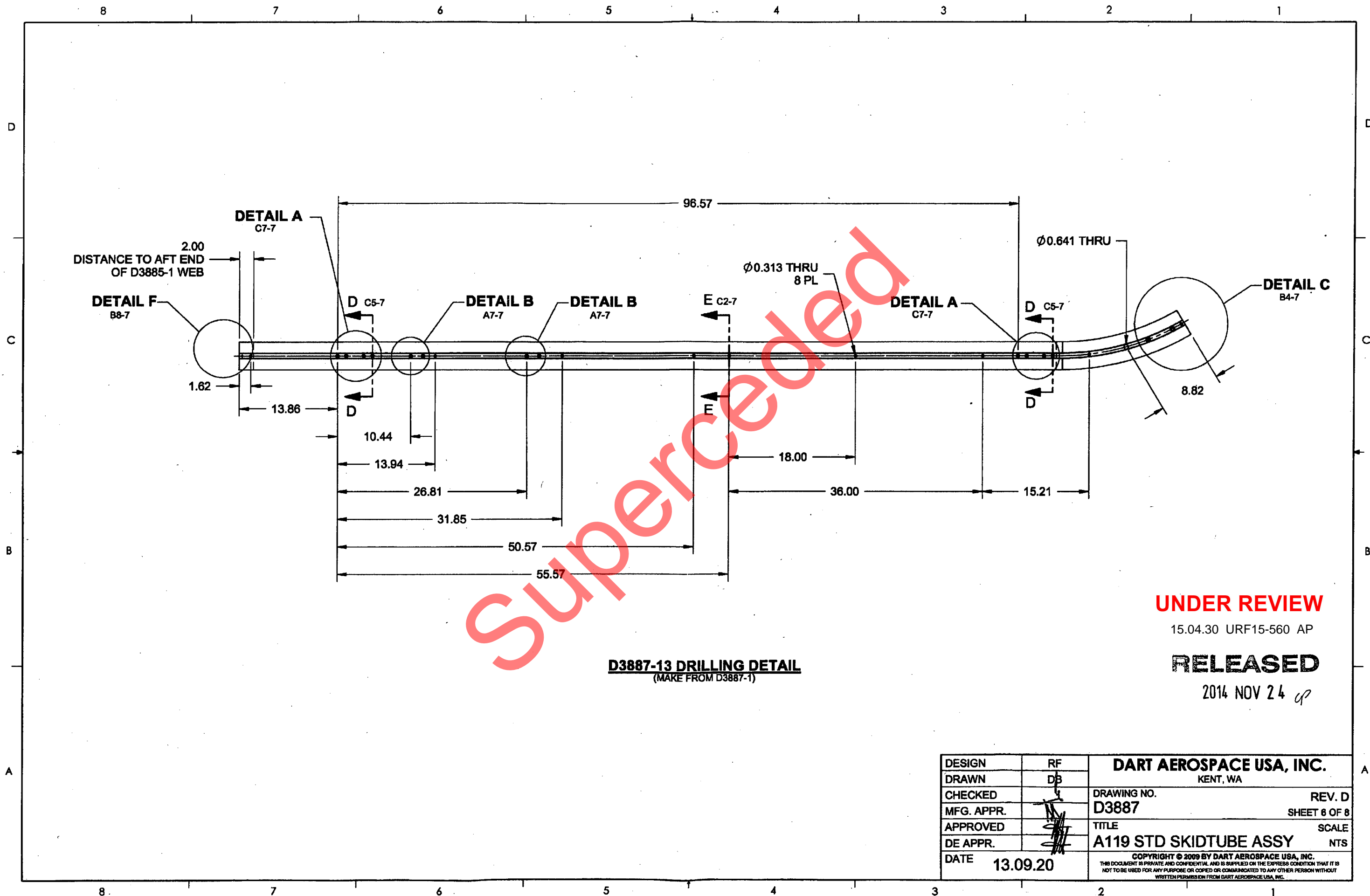
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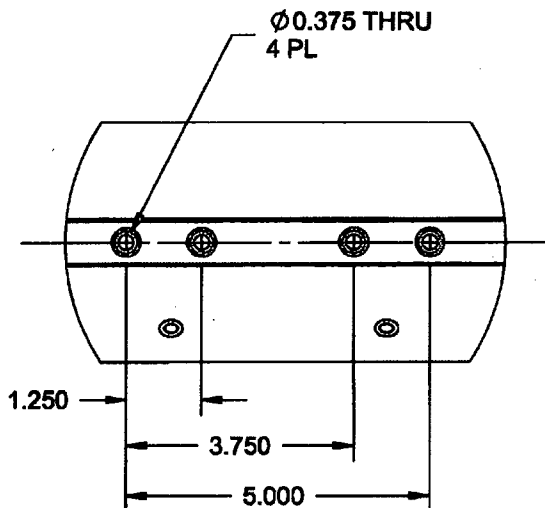
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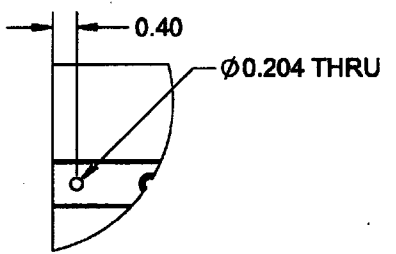
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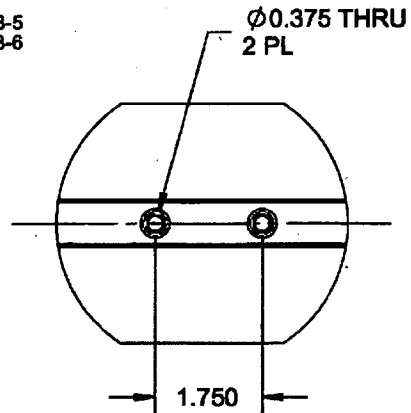




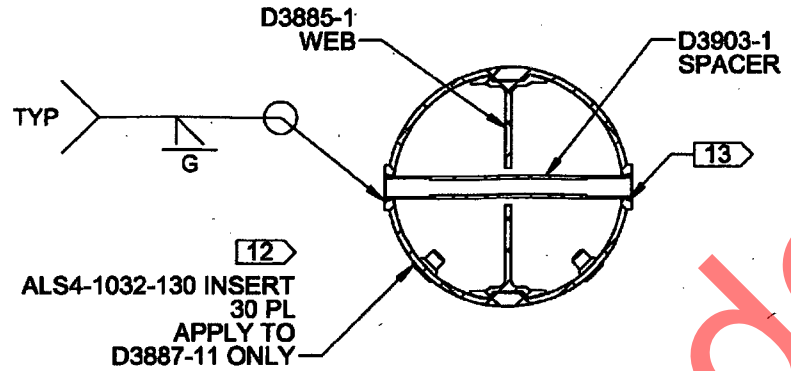
DETAIL A
SCALE 4X
D7-5
C3-5
D7-6
C3-6



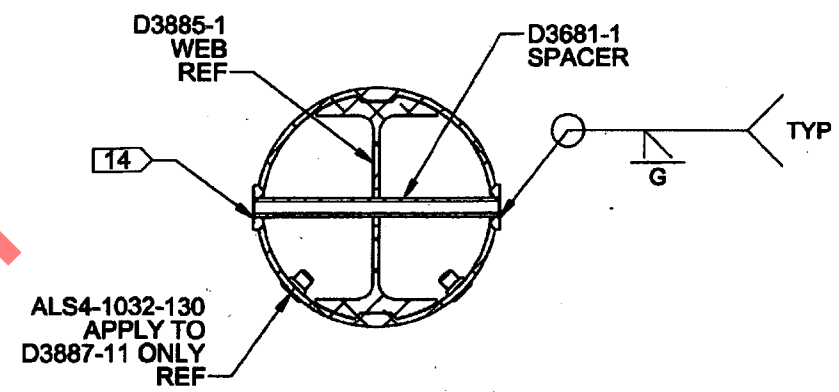
DETAIL F
SCALE 4X
C8-5
C8-6



DETAIL B
SCALE 4X
C6-5
C5-5
C6-6
C5-6



SECTION D-D
SCALE 4X
C7-5
C3-5
C7-6
C2-6
(FOR 12 X Ø0.375 HOLES PER SKIDTUBE)



SECTION E-E
SCALE 4X
C4-5
C4-6
(FOR 8 X Ø0.313 HOLES PER SKIDTUBE)

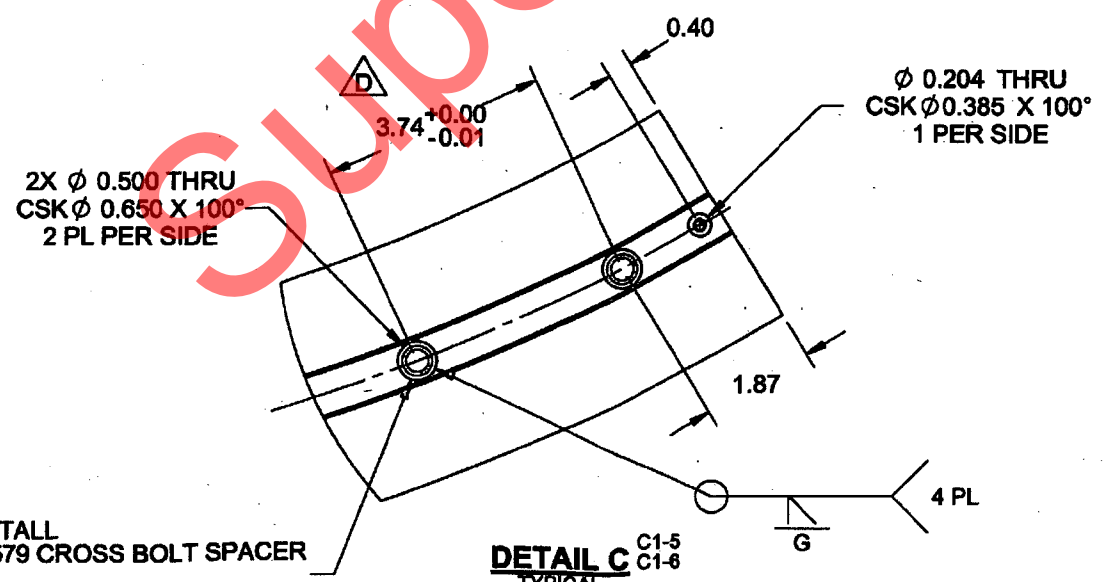
- NOTES:**
- 13) AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
- i) CHAMFER HOLES Ø0.475 x 45°
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO 0.313 x 0.75 DEEP
 - v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.313 HOLES ONLY:
- vi) CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
 - vii) INSERT D3681-1 SPACER
 - viii) WELD INTO PLACE AND GRIND FLUSH
 - ix) DEBURR HOLES

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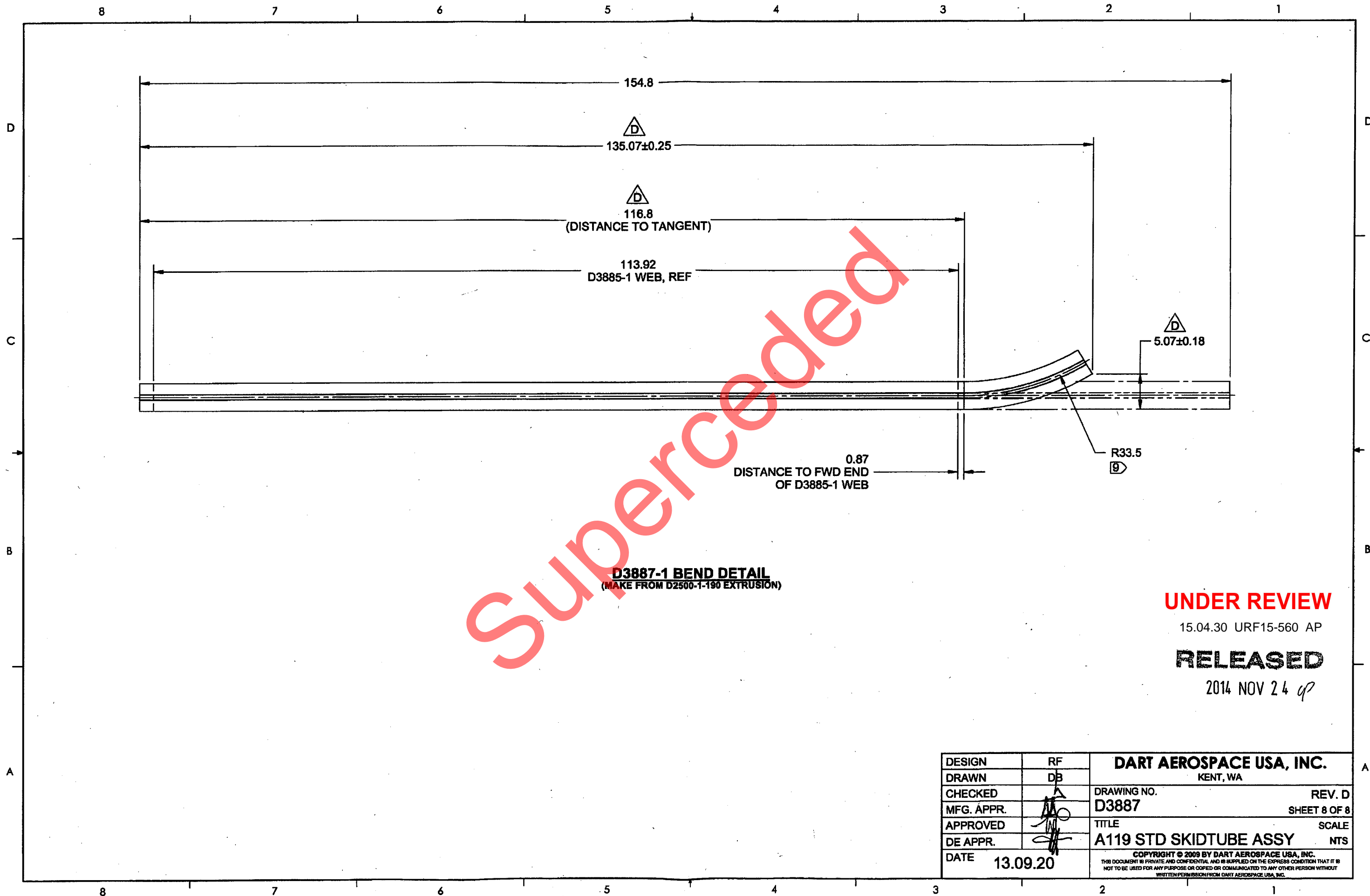
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DETAIL C
TYPICAL
SCALE 4X
C1-5
C1-6

| | | | |
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





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